

Work Order ID 77447

December-07-11 11:05:52 AM

77447

Page 1

Item ID: D350-578-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw **7**
 Start Date: 07/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 28/12/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/12/07 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2432	Rev F3

100 DOCUMENT CONTROL **30e** 0.00
100
 DC Memo 0.00
 Document Control Photocopy bluefile and create labels per PPP D350-578-011 CHG005

160 Pick Kit 0.00
160
 Packaging Memo 0.00
 Packaging

170 QC4- 100% Inspect kits for completeness 0.00
170
 QC Memo 0.00
 Quality Control

12 01 25 (7)
12-1-24 (8)

12/1/24 SPC

12 01 25 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77447

December-07-11 11:05:52 AM

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Page 2

Item ID: D350-578-011

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 07/12/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 28/12/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-578-011 Location: <u>12-12</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12-01-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-07-11 11:05:57 AM

Page 1

Work Order ID: 77447

77447

Parent Item: D350-578-011

D350-578-011

Parent Item Name: Bearpaw

Start Date: 07/12/2011

Required Date: 28/12/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A
AN4-17A
Bolt

Purchased	No	160	Each	600.0000	12	96	**
-----------	----	-----	------	----------	----	----	----

Location	Loc Qty	Loc Code
ST359	600	
118628	200	
118983	300	
119798	100	

D2182B
D2182R
Rubber Cushion

Manufactured	No	160	f	650.0942	2.5	20	**
--------------	----	-----	---	----------	-----	----	----

Location	Loc Qty	Loc Code
ST410	650.09417	
66063	59.94817	
73932	590.146	

Cut qty 6 at 5.00" long
D2274
D2274
Radius Block

Manufactured	No	160	Each	191.0000	12	96	**
--------------	----	-----	------	----------	----	----	----

Location	Loc Qty	Loc Code
ST010	1	
73389	1	
ST139	190	
74435	190	

D2432
D2432
206 (24") Bearpaw

Manufactured	No	160	Each	0.0000	2	16	**
--------------	----	-----	------	--------	---	----	----

Handwritten notes and signatures at the bottom right of the page, including "B77034", "B78589", "12/1/24", and "B78322".

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 77447

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Parent Item: D350-578-011

D350-578-011

Parent Item Name: Bearpaw

Start Date: 07/12/2011

Required Date: 28/12/2011

Start Qty: 8.00

Required Qty: 8.00

D2438
Clamp

Manufactured No 160 Each 181.0000

**

Location

Loc Qty

Loc Code

ST456

181

69737

84

73400

97

Manufactured No 160 Each 534.0000

**

Location

Loc Qty

Loc Code

ST016

534

71161

34

76086

500

Purchased No 160 Each 9,987.000

**

Location

Loc Qty

Loc Code

ST300

526

117441

51

117601

342

118451

133

ST516

4461

119017

4461

ST518

5000

119075

5000

MS210421 4
Nut

Purchased No 160 Each 9,987.000

**

Location

Loc Qty

Loc Code

ST300

526

117441

51

117601

342

118451

133

ST516

4461

119017

4461

ST518

5000

119075

5000

December-07-11 11:05:57 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

December-07-11 11:05:57 AM

Page 3

Work Order ID: 77447

77447

Parent Item: D350-578-011

D350-578-011

Parent Item Name: Bearpaw

Start Date: 07/12/2011

Required Date: 28/12/2011

Start Qty: 8.00

Required Qty: 8.00

NAS1149D0463J

Purchased

No

160

Each

10,232.00

24

192

NAS1149D0463.I

Washer

**

01/12/24

\$ 80

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

278

116025

16

116805

0

117291

1

117460

2

118179

17

118384

228

118612

3

119042

11

ST407

9929

119075

9760

119097

169

192

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

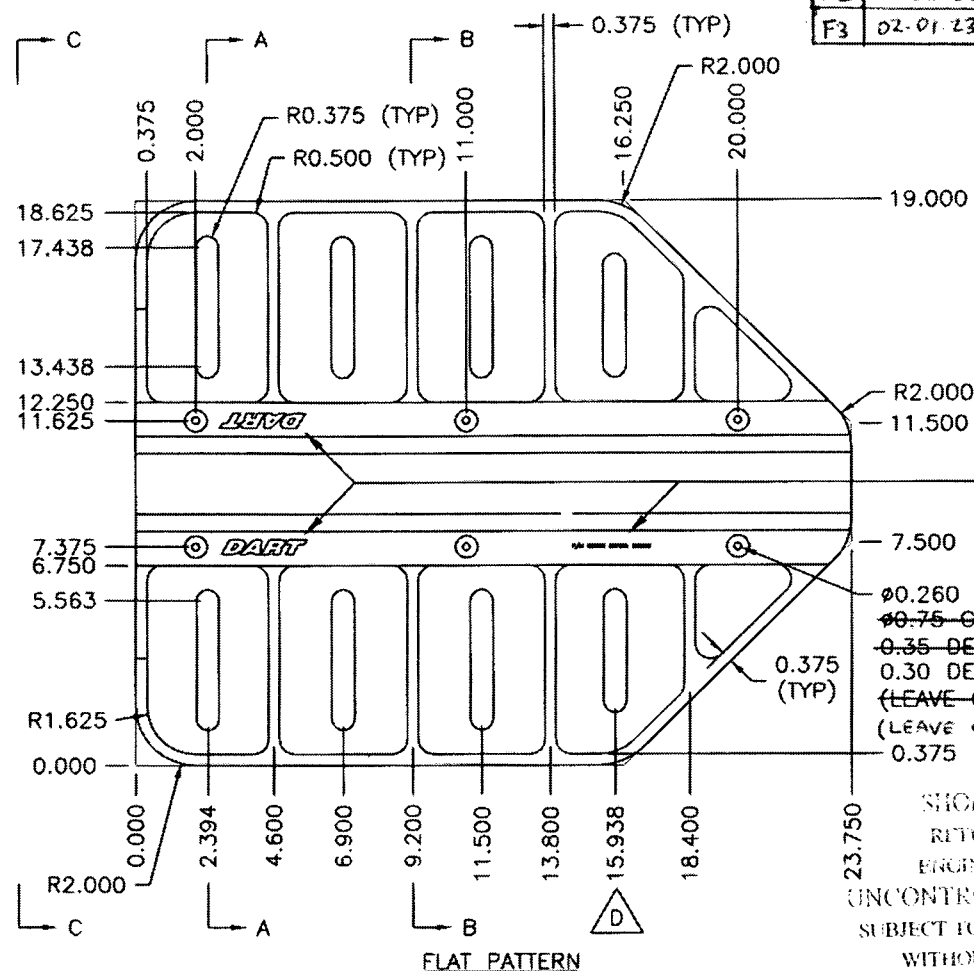
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

RELEASED
98.06.17 KB



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ ~~Ø0.93 C'BORE~~
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77447

EFFECTIVE DEOS

9143	
------	--

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	KE	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE 1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

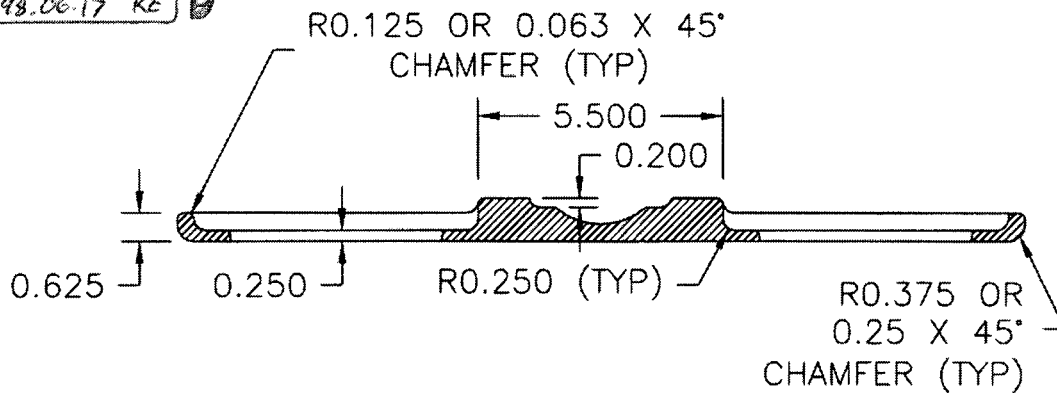
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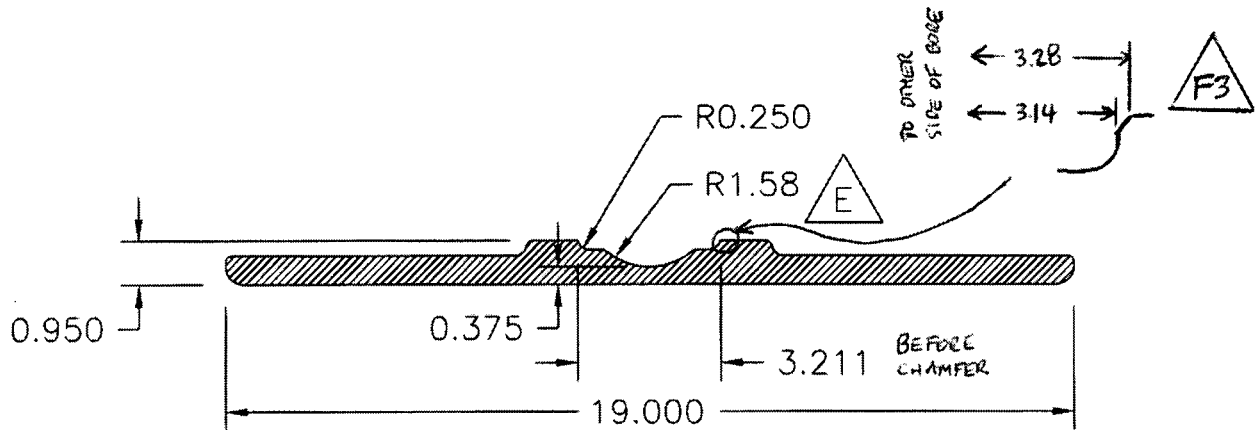


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

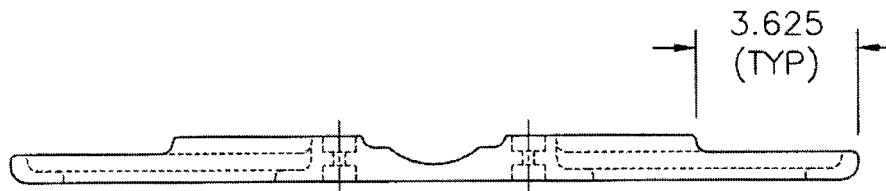
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

thntv

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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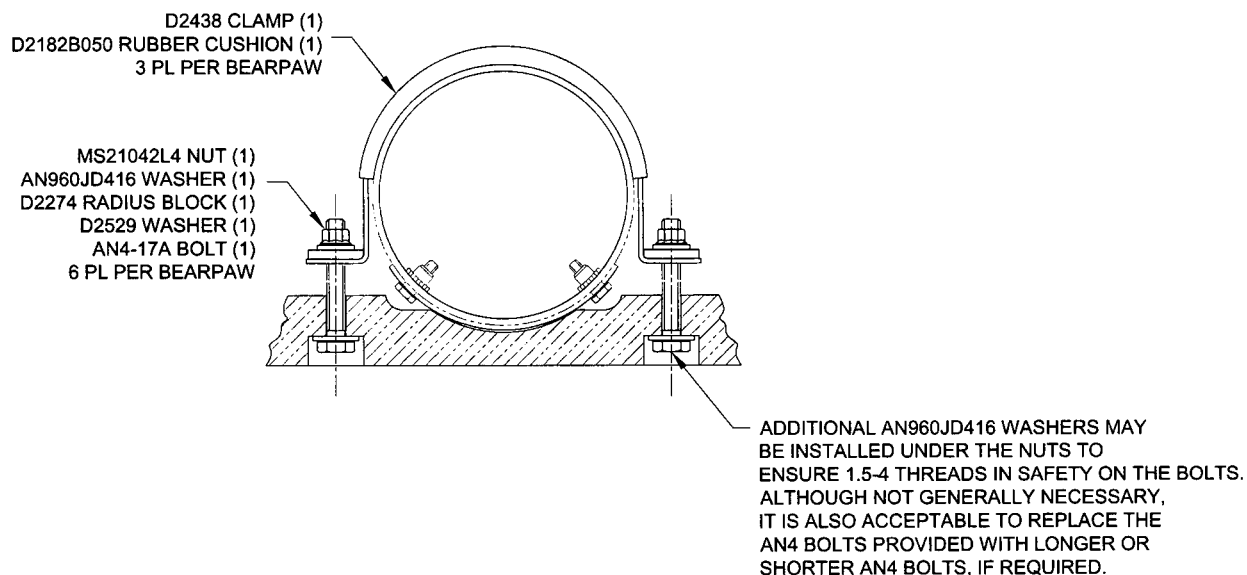
NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D350-578

Page 8 of 8



Section A-A
Figure 4 – Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion }
12	12	D2274	Radius Block }
12	12	D2529	Washer }
6	6	D2438	Clamp }
2		D2432F	Bearpaw }
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt }
24	24	AN960JD416	Washer }
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: F
Date: 08.08.28